

Date: Friday, 01/08/2008 3:31:52 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	END FITTING ASS'Y LH
Job Number :	40960		
Estimate Number :	13344		
P.O. Number :		Part Number :	D3763043
This Issue :	01/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3763 REV B
First Issue :	1/1	Project Number :	N/A
Previous Run :	40959	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JUL 08.8.05	Due Date :	21/08/2008
Comment :	Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0	D37631	End Fitting
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

End Fitting

batch:

B 40994 ✓

SP

08.08.13

(SK)

3.0	D37635	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

batch:

B 40705 ✓

SP

08.08.13

(4K)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-make a 0.063" chamfer on D3763-1 fitting before ass'y

SP 08.08.13

2-assemble and tack weld as per dwg D3763 using locating pin

SP 08.08.13

*****look at dwg before assembling parts (LH)*****

*****remove pin before welding*****

3-weld as per dwg D3763 QSI004

Alum. rod Batch:

M 108037

SP 08.08.13

(4K)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y LH

Job Number: 40960

Part Number: D3763043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



08-08-14



(X4)

Comment: VISUAL WELDING INSPECTION

08/08/14

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-08-14 (V)



(P10)

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

MF 08-08-14

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

Job Completion



MF 08-08-14

6.1 chemical conversion cost.

08/08/14

(X4)



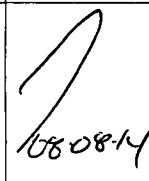
6.2 QC3 08-08-14

(X4)

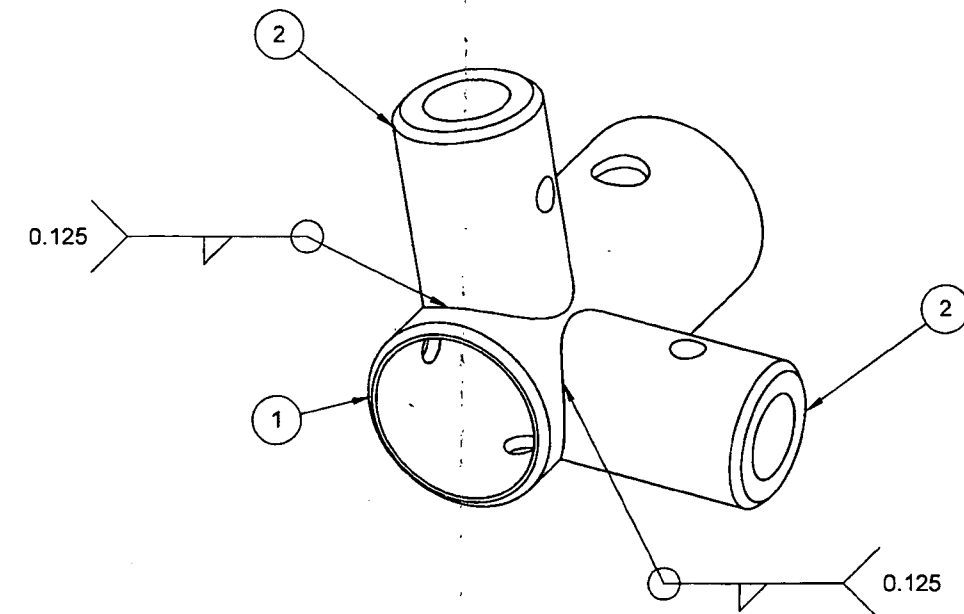
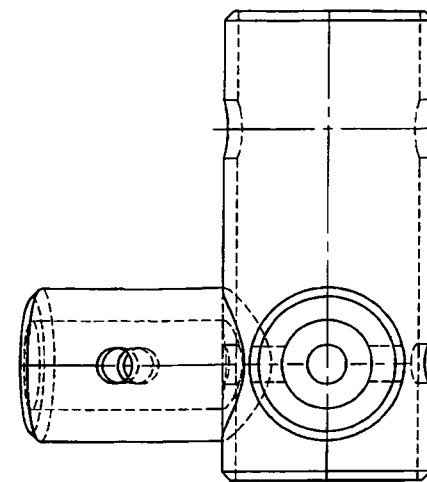
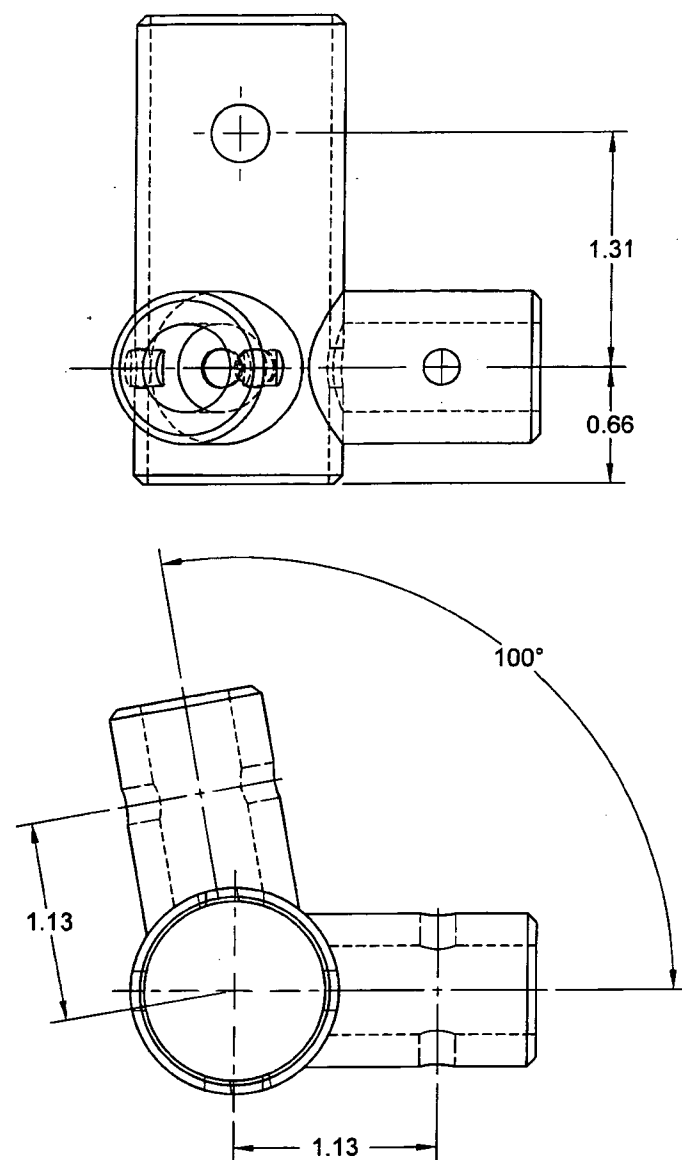
Dart Aerospace Ltd

WIO: 40960		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE:	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-043 PAR #: N/A Fault Category: Procl. Eng. Co-ord. NCR: Yes No DQA: 12 Date: 08/08/15
 QA: N/C Closed: 12 Date: 08/08/15

NCR: 40960		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0808-14	6-0	No chemical conversion cust step on Estimate. - was were verified	 08/08/15	Add Alodine to I.P.P. i.e. A QC3			 08/08/15	 0808-14

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2


D3763-043 END FITTING ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

RELEASED
08-01-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40960

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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